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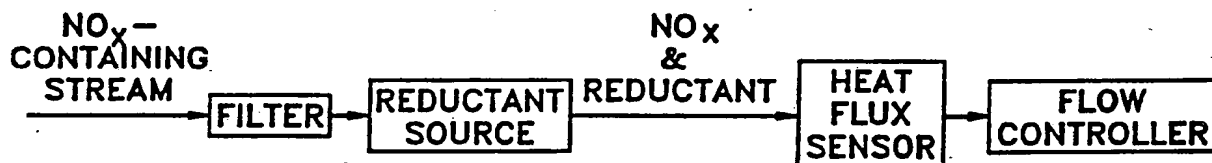
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(21) International Application Number: PCT/US91/04177 (22) International Filing Date: 12 June 1991 (12.06.91) (30) Priority data: 536,888 12 June 1990 (12.06.90) US (71) Applicants: CATALYTICA, INC. [US/US]; 430 Ferguson Drive, Building 3, Mountain View, CA 94043 (US). WHEELock, E., Thomas [US/US]; Catalytica, Inc., 430 Ferguson Drive, Building 3, Mountain View, CA 94043 (US). (72) Inventors: DALLA BETTA, Ralph, D. ; 865 Doverton Square, Mountain View, CA 94040 (US). REED, Daniel, L. ; 213 Spyglass Parkway, Vallejo, CA 94591 (US). SCHUBERT, Priscilla ; 436 Inverness Drive, Pacifica, CA 94044 (US).		(74) Agent: WHEELock, E., Thomas; Catalytica, Inc., 430 Ferguson Drive, Building 3, Mountain View, CA 94043 (US). (81) Designated States: AT (European patent), AU, BE (European patent), BR, CH (European patent), DE (European patent), DK (European patent), ES (European patent), FR (European patent), GB (European patent), GR (European patent), IT (European patent), JP, KR, LU (European patent), NL (European patent), SE (European patent). Published <i>With international search report.</i>

(54) Title: NO_x SENSOR ASSEMBLY**(57) Abstract**

This invention is a self-contained NO_x sensor assembly. It may be used to detect NO_x levels in a flowing gas stream such as might be found in an exhaust gas from a combustion process and to produce a measurable electrical output related to the content of NO_x measured. The NO_x sensor assembly is of a configuration that may be detached from a mounting and replaced. The sensor assembly comprises two sensor elements one of which is made up of a catalyst on a temperature measuring device. The other is a gas stream ambient temperature measuring device. The catalyst is selected and configured so that it selectively reduces NO_x and the resulting heat of the reaction raises the temperature of the allied temperature measuring device. The sensor assembly also contains a NO_x reductant source. The sensor assembly may be placed in a moving vehicle for measuring NO_x levels in its exhaust gas.

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NO_x SENSOR ASSEMBLYFIELD OF THE INVENTION

5 This invention is a self-contained NO_x sensor assembly. It may be used to detect NO_x levels in a flowing gas stream such as might be found in an exhaust gas from a combustion process and to produce a measurable electrical output relative to the content of NO_x measured. The NO_x sensor assembly is of a configuration that may be mounted in motor vehicles and
10 other mobile locations, requires low power, and no additional chemical reagents.

The sensor assembly comprises two sensor elements one of which is made up of a catalyst on a temperature measuring device. The other is a gas stream ambient temperature measuring device. The catalyst is selected and
15 configured so that it selectively reduces NO_x and the resulting heat of reaction raises the temperature of the allied temperature measuring device. The sensor assembly also contains a NO_x reductant source.

The sensor assembly may be placed in a moving vehicle for measuring NO_x levels in its exhaust gas.

20

BACKGROUND OF THE INVENTION

Exhaust gases produced by burning fuels using air as the source of oxygen typically contain small but significant amounts of various nitrogen oxides (NO, NO₂, N₂O₃, etc.) collectively and interchangeably known as NO_x.
25 NO_x is often present in these exhaust gases whether the source is a stationary source such as a boiler or is mobile such as an automobile or truck. Although small, the NO_x content is a necessary and, therefore, undesirable participant in the photochemical reaction creating modern "smog".

There are a number of ways in which the NO_x may be removed or
30 treated or even its initial synthesis prevented; however, each such process strongly benefits from use of an accurate monitor for detecting low levels of NO_x. The detector may be used in a variety of processes to reduce the amount of NO_x the process produces such as by:

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1. converting NO_x to N_2 by reaction with a reductant such as NH_3 where the reductant addition rate is controlled by the level of NO_x found in the stream to be treated,
2. controlling the rate of exhaust gas recirculation ("EGR") to lower flame temperature and, therefore, the NO_x level, and
3. adjusting boiler burner operations, including dilution air flow, to control NO_x production levels.

There are, however, few low level NO_x sensors available which are practically suitable for inclusion in closed loop controllers or for mobile use.

Major problems found in the prior measurement devices have included the lack of sensitivity and toughness. An ability to measure low levels of NO_x in mobile source combustion gases is desirable.

There are a number of methods known for detecting NO_x in flowing gas streams. Perhaps the most well-known of the processes currently used involves instruments using the chemiluminescent reaction of nitric oxide and ozone. The accuracy of many NO_x sensors, including chemiluminescent sensors, suffers because of interference from other gases which may be found in a combustion gas stream, e.g., SO_2 , CO , H_2 , H_2O , and various hydrocarbons. Additionally, ozone is highly reactive and often raises reactivity problems with analyzer components, e.g., O-rings, metals used in the analyzer, and the like. The process operates by the reaction of injected ozone and the nitric oxide in a sample within a reaction chamber having a transmissive window through which the light produced by the chemiluminescent reaction is monitored by a detector. The window in the reaction chamber must be kept scrupulously clean to maintain analyzer sensitivity and calibration. Water causes substantial problems in these devices. Typical apparatus using this process may be found in U.S. Patent Nos. 3,967,933 to Etess *et al.*; 4,236,895 to Stahl; 4,257,777 to Dymond; 4,315,753 to Bruckenstein *et al.*; and 4,822,564 to Howard. The use of a chemiluminescent nitrogen oxide monitoring device in controlling a nitrogen oxide removal unit placed on the outlet of a boiler is shown in U.S. Patent No. 4,188,190 to Muraki *et al.* The devices disclosed herein could be substituted for the nitrogen oxide sensors shown in the Muraki

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et al. Because of the sensitivity of the optical portions of the devices to vibration, and due to the size and cost of these devices, the use of chemiluminescent analyzers is wholly unsuitable for mobile source NO_x sensors.

5 Another procedure involves the use of an infrared beam, detector, and a comparator chamber. In U.S. Patent No. 4,647,777 to Meyer, a beam of infrared light is passed through a gas sample and into a selective infrared detector. The beam is split and one portion passes through a chamber containing a fluid which absorbs the spectral wavelengths of the selected gas.
10 The two beams are compared and the difference between the two beams gives an indication of the amount of selected gas in the sample. Although such instruments can measure NO and NO_x, they suffer from the same shortcomings as do the chemiluminescent analyzers: clean optical surfaces are required, significant sample pretreatment is required, and the instrument
15 has significant maintenance requirements.

U.S. Patent No. 4,836,012 to Doty et al. shows a semiconductor device made up of a photovoltage cell which, upon exposure to light, develops a voltage or current which varies as a function of the type of gas sorbed. The device requires a "thin light-transmitting gas-absorbing metal Schottkey layer
20 having electrical properties which vary with the type of gas sorbed". Detection of CO, hydrocarbon, water vapor, etc., is suggested; detection of NO is not.

Other methods of determining the trace amounts of NO_x which may be present in a gas stream are known. For instance, U.S. Patent No. 3,540,851 to Vree et al. suggests a process in which a gaseous mixture containing
25 substituents such as carbon oxides, nitrogen oxides, sulfur oxides, and oxygen is separated into two streams. One stream is desirably mixed with a ballast gas and sent into a reference arm of a measuring apparatus; a second stream is passed after mixing both with nitrogen and a carrier gas, such as helium, and subjected to an electric discharge. The thus treated gases are passed
30 through a conventional electrometer. The excited NO_x passes to an ionic state and gives off a measurable electron.

U.S. Patent No. 4,115,067 to Lyshkow suggests a process for using a substrate which is sensitive to the pollutant to be measured and monitoring the

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change in color or reflectivity of the sensitized substrate. Lyshkow suggests the use of a substrate upon which silica which has been impregnated with a mixture of sulfanilic acid and N-(1-naphthyl)-ethylenediamine dihydrochloride. The mixture reacts with NO₂, changes the color of the substrate, and
5 decreases the reflectivity of the substrate having the silica gel coating. Lyshkow suggests that the treated substrate be contacted with the gas to be measured and moved at a constant rate past a device which measures the change of reflectivity of the surface. In this way the amount of NO₂ is measured.

10 The U.S. Patent No. 4,778,764 to Fine describes a device and a process in which a sample is injected with a solvent into a liquid chromatographic column to separate the various materials present in the sample. The output of the column is then burned in the presence of a variety of detectors for one or more of NO_x, SO₂, CO₂, and halogens.

15 U.S. Patent No. 4,840,913 to Logothetis *et al.* suggests a method for sensing nitrogen oxides, particularly in the exhaust flow of an internal combustion engine. The gas is passed through an oxidation catalyst which is formed over an oxide sensor. The oxidation catalyst is intended to oxidize all reducing species (CO, H₂, hydrocarbons, alcohols, etc.) which are carried in
20 the gas to be measured. Nitrogen monoxide is oxidized to NO₂ as well. The oxidized gas passes to an oxide sensor such as a SnO₂ or ZnO.

U.S. Patent No. 4,473,536 to Carberg *et al.* suggests a process for controlling a NO_x reduction process using a nonspecific NO_x sensor.

25 None of the above disclosures suggest a process or an apparatus in which a catalytic element is used to detect the presence of a gaseous component. Because of their complexity, none are suitable for use in mobile NO_x sources such as automotive spark ignition or diesel engines.

The concept of using the temperature rise of a gas as it passes through a catalyst bed as an indicator of the content of a component of that gaseous
30 mixture has been shown. For instance, in U.S. Patent No. 2,751,281 to Cohen, a method is taught for measuring low concentrations of gas impurities, such as oxygen, in the range of 0.0001% to 0.001%. A thermocouple is placed such that a cold junction is on the upstream side of a bed of catalyst and the hot

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junction is placed on the downstream side of that bed. As the gas flows across the catalyst, the temperature of the gas rises and is detected and the impurity content of the incoming gas is calculated. U.S. Patent No. 3,488,155 to Ayers shows a similar process in which the temperature on each side of a
5 hydrogenation catalyst bed is measured during the flow of a gas containing hydrogen. The temperature difference is related to the hydrogen content of the incoming gas stream.

The U.S. Patent No. 3,537,823 to Ines suggests a process for measuring the quantity of "smog forming hydrocarbons in a gas sample" by
10 measuring the temperature rise in an oxidation catalyst bed. Moreover, a related process is found in U.S. Patent No. 3,547,587 also to Ines.

U.S. Patent No. 3,607,084 to Mackey et al. teaches a process for the measurement of a combustible gas content by locating a pair of wires in a small chamber containing a volume of gas with combustibles therein. One wire
15 is coated with a catalytic mixture of a metal oxide and a powdered metal of the platinum group and the other is apparently uncoated. Electrical power supplies heat to both wires. The difference in resistance caused by the change in temperature of the wire coated with the catalytic mixture provides an indicator of the amount of combustibles in that gas chamber.

20 U.S. Patent No. 4,170,455 to Henrie also suggests a method for the monitoring of the hydrogen or oxygen content of a gas stream by measuring the temperature upstream and downstream of an oxidation catalyst. U.S. Patent No. 4,343,768 to Kimura shows a gas detector formed using semiconductor technology. The detector uses dual heating elements over a
25 channel adapted for gas flow. One of the heating elements is coated with a "catalytic or gas responsive film" which may be platinum or palladium. The increase in the temperature of the catalytic film is detected in terms of the variation in electrical resistance in the content of the gas stream calculated.

Finally, U.S. Patent No. 4,355,056 to Dalla Betta et al. suggests a
30 differential thermocouple combustible sensor in which one junction of the thermocouple is catalytically coated and the other junction is not. The gas stream contains such gases as carbon monoxide and hydrogen and the sensor is said to be "insensitive to contaminants such as SO₂ and NO".

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None of these disclosures teaches a self-contained NO_x sensor assembly containing a NO_x reductant source and a catalytic NO_x detector which is suitable for placement in a moving vehicle where size, weight, power requirements, and cost are important factors.

5

BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 is a block diagram of this inventive device.

Figure 2 shows schematically where the inventive device may be used.

Figure 3A-3E show a number of variations of the inventive device.

10

Figure 4 shows a typical heat flux sensor useful in the inventive device.

SUMMARY OF THE INVENTION

As was noted above, the invention is a self-contained NO_x sensor assembly suitable for measuring NO_x in a flowing gas stream such as might be found as the exhaust of an internal combustion engine burning diesel or gasoline type fuels.

15

The self-contained NO_x sensor assembly is made up of a housing which contains the rest of the elements, a NO_x reductant source, and heat flux detector to detect the reaction between the NO_x and the NO_x reductant. The NO_x sensor assembly desirably also contains a flow controlling device such as an orifice to control the flow rate of gas to be measured through the NO_x sensor assembly and heaters to control the temperature of the NO_x reductant source and the catalytic sensor element. Other elements may include filters for remaining particulate matter, connectors for measurable output, baffles for shielding the heat flux assembly, etc.

20

25

The heat flux detector may be made up of two major discrete functional portions: a catalytic sensor element and a reference sensor element. The catalytic element has on its outside periphery a catalyst; in thermal contact is a temperature measuring device. Both are generally thermally isolated from the operating environment and each other. The catalyst is selected and merged with the temperature measuring device so that the NO_x in the flowing gas stream is selectively reduced to N₂ and H₂O on the catalyst surface using an added NO_x reductant. The NO_x reductant is supplied by the NO_x reductant

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source. The temperature measuring device may be well-known devices such as resistance-temperature-detectors (RTD), thermistors, or thermocouples which detect the small temperature rise occurring due to the NO_x reduction reaction taking place on the catalyst. The catalyst and temperature measuring device should be in close (ideally, contiguous) physical proximity and constructed in such a way that they retain most of the heat of reaction produced by the reduction reaction. The heat of reaction should then cause only the temperature of the temperature measuring device in communication with the catalyst to rise. Baffles or shields may be used in the vicinity of the catalytic sensor element to lessen the amount of heat which is radiated away from that catalytic element either to the reference element, if one is used, or to other surrounding portions of the NO_x sensor assembly.

The NO_x reductant source desirably is a material capable of releasing a reactant which is capable of reducing NO_x on the catalytic surface at the heat flux assembly but not elsewhere. An especially desirable source is cyanuric acid which sublimates into a reductant gas in a suitable temperature range.

The temperature of the catalytic sensor element is obviously converted to an electrically measurable quantity (voltage, resistance, etc.) by the temperature measuring device and is compared to the analogous quantity from the reference element. The difference in temperature is proportional to the NO_x concentration in the measured gas.

The NO_x sensor assembly has an exhaust gas stream containing NO_x drawn or pressured through it. The stream picks up an amount of NO_x reductant from the NO_x reductant source, the NO_x and the NO_x reductant react at the catalytic sensor element to produce a temperature rise at the temperature measuring device, the electrical quantity (voltage, resistance, etc.) is measured and compared to the quantity produced by the reference sensor element, and the gas is then disposed of.

30

DESCRIPTION OF THE INVENTION

This invention is a self-contained NO_x sensor assembly as shown in Figure 1 (in block form) comprising an optional filter, a NO_x reductant source, a heat flux sensor assembly comprising a catalytic sensor element capable of

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detecting NO_x by reacting NO_x with the NO_x reductant and measuring the resulting temperature rise and a reference element capable of measuring the ambient temperature of the gas stream containing both NO_x and NO_x reductant, and some form of flow controller.

5 Desirably, the self-contained NO_x sensor assembly is of a configuration which is compact, rugged, and uses the temperature of the measured gas to maintain the temperature of the catalytic sensor element at an approximate operating temperature and vaporize or cause sublimation of the NO_x reductant. For instance, as shown in Figure 2, the NO_x sensor assembly can be mounted
10 in the exhaust line of an internal combustion engine. However, for exhaust gas of a typical vehicular internal combustion engine in which the temperature varies widely depending upon engine speed and load, the temperature of the sensor and the NO_x reductant may be controlled by separate heaters and controllers. The electrical output signals can be fed to an electronics package
15 for determination of NO_x level in the exhaust. That electronic NO_x information could then be sent to a computer controller for an exhaust gas recirculation (EGR) valve. EGR valves, by recirculating exhaust gas to the combustion chambers, lower the amount of NO_x produced by the engine.

Ideally, the NO_x sensor assembly should be fairly small. The amount of
20 exhaust gas passing through the assembly could be in the neighborhood of 1 to 5 cc/minute. Such a sample flow rate permits storage of correspondingly small amounts of NO_x reductant within the sensor assembly housing. This also imposes an effective size limitation on the heat flux sensor assembly; both the catalytic sensor element and the reference element, if used, must be of a
25 relatively small size to detect NO_x in such small flowing streams.

One simple embodiment of the inventive self-contained NO_x sensor assembly is found in Figure 3A. Figures 3B through 3E show variants on the section of the NO_x sensor assembly containing an integral NO_x reductant source.

30 The container (102) for the NO_x sensor assembly may be in the shape shown in Figure 3A or may be in other convenient shapes, e.g., canisters or shapes conforming to the apparatus into which they fit. As noted above, the inventive device may use the temperature of the combustion gas or exhaust

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apparatus as the heat source to maintain the temperature at an appropriate operating temperature heat. However, in most instances the sensor will require separate heaters to maintain and control the temperature at an appropriate value. Conformance of the shape to an exhaust manifold or exhaust pipe is acceptable. Container (102) shows a threaded end (104) for mating to the NO_x-containing gas source. A similar threaded end (106) is shown at the exit of the inventive device.

The NO_x-containing exhaust gases enter through port (108). If the NO_x sensor assembly is to be used with a "dirty" exhaust gas, e.g., one containing particulates such as might be found in a diesel exhaust, optional filter (110) may be incorporated in the NO_x sensor assembly. The filter may not be needed for cleaner burning fuels or combustion sources.

One excellent way of drawing NO_x-containing exhaust gases through the self-contained NO_x sensor assembly is by connecting the end of container (102) having exit port (112) to a vacuum source such as the manifold vacuum found in a carbureted or fuel injected Otto cycle engine. This produces a gas flow through the device in the direction of the arrows shown in Figure 3A. The orifice (114) in baffle (116) may be sized so that it is a critical orifice, that is, the flow through the orifice is at sonic velocity thus producing a constant flow rate of gas to be analyzed through the NO_x sensor assembly independent of small changes in vacuum and partial plugging of particulate filter (110).

After the exhaust gas containing NO_x passes through port (108) and particulate filter (110), it encounters optional restrictor (118). Restrictor (118) may be used to minimize back diffusion of NO_x reductant from NO_x reductant source (120). If desired, the function of restrictor (118) and particulate filter (110) may be combined by choosing, for instance, a fritted metal material having significant flow resistance as the particulate filter (110).

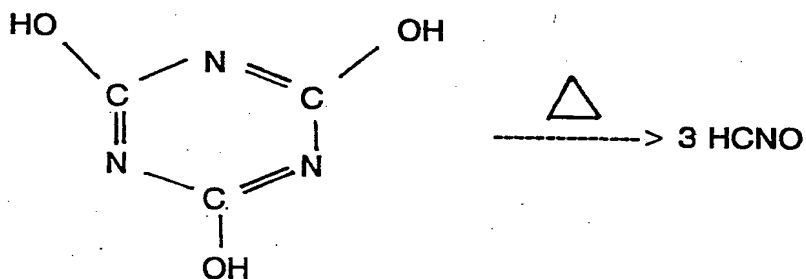
The NO_x reductant source (120) may be in the form of a porous block emanating NO_x reductant. The block may comprise an inert solid, such as carbon or a ceramic, which contains the NO_x reductant or it may be of a material which sublimates or reacts to produce a NO_x reductant. Examples of suitable solid materials include urea, cyanuric acid, ammonium carbonate, etc. The solid reductant may be absorbed on the surface of a fibrous support or in

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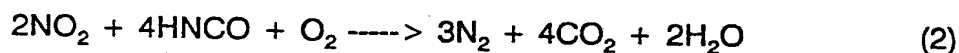
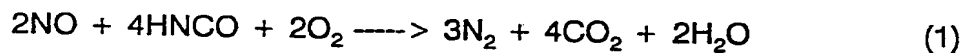
the pores of a porous inert support. It is desirable to have the reductant dispersed on the surface of a high surface area support to maximize the reductant's surface area and promote its vaporization into the gas stream. Additionally, it is desirable to maximize the quantity of reductant in the sensor assembly to provide long life. An optimum surface area and quantity of reductant will take into consideration these opposing objectives. At appropriately low flow rates, the NO_x-containing gas will be effectively saturated with the NO_x reductant vapor for passage to the heat flux sensor assembly downstream.

Although not desired because of the bulk required in carrying an amount of NO_x reductant, NH₃ may be used as the NO_x reductant by replacing the integral NO_x reductant source (120) with an injector nozzle.

The preferred NO_x reductant is cyanuric acid (a solid) which upon heating decomposes to produce isocyanic acid according to the following reaction:



Isocyanic acid reacts with the various nitrogen oxides (e.g., NO, NO₂, etc.) which collectively make up NO_x in a strongly exothermic reaction according to the following illustrative reactions:



Other reactive stoichiometries and, indeed, other reactions are possible to reach the same general result. The above reactions are only examples.

The gas stream should contain an excess of NO_x reductant as based on

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the NO_x present in the gas stream. Said another way, to achieve accurate measurements, the limiting reactant must be the NO_x . As a rule of thumb, internal combustion engines contain no more than 500 ppm of NO_x and the reductant must be present at a level in excess of that required to reach with
5 the NO_x . For instance, the reactions shown in equation (1) and (2) would require an isocyanic concentration of 1000 ppm for a NO_x concentration of 500 ppm.

Perry, "Rapid Reduction of Nitrogen Oxidizing in Exhaust Gas Stream", *Nature*, December, 1986, Vol.18/25, has reported that 90% of the NO present
10 in a stream containing 400 ppm is reacted to N_2 using cyanuric acid at 325°C in the presence of a suitable catalyst. When cyanuric acid is chosen as the NO_x reductant source (120), a temperature of about 330°C is appropriate to achieve the necessary concentration of isocyanic acid. Although placement of the NO_x sensor assembly near the exhaust manifolds (when used with internal
15 or external combustion engines) or near the combustion source in other services (when used with boilers, furnaces, etc.) may be appropriate in some services, auxiliary heating of the NO_x reductant source (120) may be needed (during cold start up) or desired (because of NO_x sensor assembly placement remote from the heat source) such as by heaters (122). The NO_x -containing
20 gas also containing NO_x reductant then passes to a heat flux sensor assembly (124). In many services, the temperature of the NO_x -containing gas stream as it passes the heat flux sensor assembly (124) is controlled to be different than that of the NO_x sensor source.

Heaters (122) and (126) would usually be electric. We have found that
25 sufficient cyanuric acid is sublimated at above 260°C to provide an efficiently operable NO_x sensor assembly. The heater (122) for the cyanuric acid NO_x reductant preferably operates at 265°C to 280°C . The heater (126) for the gas approaching the heat flux sensor assembly (124) desirably operates at a temperature of 280°C to 340°C , preferably 320°C to 335°C .

30 Figures 3B through 3E show exemplifying variations of the NO_x reductant source. In Figure 3B, chunks of a sublimateable NO_x reductant (302) such as cyanuric acid are interspersed in a porous fibrous material (304) such as glass-wool or mineral-wool which is capable of withstanding the temperature

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of the NO_x -containing gas. An optional device for holding the wool in place (306) is shown but may be combined with other functions in the NO_x sensor.

Figure 3C shows a woven matting (308) containing NO_x reductant followed by optional packing (310) to properly place the matting (308). The
5 packing (310) may be particulate or wool.

Figure 3D shows a porous monolithic block (312) containing a sublimateable NO_x reductant such as cyanuric acid. The block may be of a porous material such as a glass or fritted metal capable of absorbing NO_x reductant and releasing it upon subsequent use. The block (312) may be
10 followed by a chamber (314).

Figure 3E shows a variation in which the NO_x reductant source is a series of solid NO_x reductant blocks (320) arranged as baffles in the flow stream. The NO_x reductant sublimates into the gas stream as it flows through the tortuous path formed by the reductant blocks. This structure is excellent in
15 that it maximizes the amount of reductant contained in the NO_x sensor assembly. Fibrous or porous structures (322) may be added as needed to mix the gas stream flowing from the maze formed by the reductant blocks.

The heat flux sensor assembly is made up of two major components which are critical to its operation: the catalytic sensor element and the
20 reference element. First, the catalytic sensor element is made up of a catalyst and a temperature measuring device. Figure 4 shows a cutaway depiction of a catalytic sensor element (410) and a reference element (412). This variation uses a thermally insulating support or substrate (414 and 416) as portions of the elements. These supports allow the respective elements to be used as
25 probes or fingers extending into the flowing gas stream (as illustrated in Figure 3A). The substrate should be a thermally-insulating support having sufficient mechanical strength to support the catalyst and temperature measuring devices in the flowing stream. The substrates (414) and (416) may be ceramic or may be a ceramic coating on a metallic support. Suitable ceramic materials
30 include fired kaolin, alumina, silica-alumina, silica, zirconia, or mixtures of these oxides. Ceramic materials which are typically used as catalyst supports are also suitable for the substrate providing that they possess the necessary mechanical strength to withstand the temperature cycling steps as the device is

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turned on and off, the lengthy times the element will spend at the desired operating temperature, and the normal mechanical shocks endured during installation and operation. These ceramic materials are also suitable because of the variety of procedures available for making the catalytic material (420) adhere to the ceramic substrate (414) and (416).

The temperature measuring device (418) may be any of a variety of devices which produce a variation in a measurable electrical property, e.g., voltage or resistance, as the temperature of the device changes. A bimetallic thermocouple, particularly a chromel-alumel thermocouple, may be cemented to the substrate (414) using known and available ceramic cements. The face of the temperature measuring device away from the support should be substantially free of gas barriers so that the gas to be measured contacts the catalytic surface (420). The temperature measuring device may be a thermistor chosen for appropriate sensitivity in the proper temperature range. If a ceramic substrate (414) is selected, the temperature measuring device need not be discrete and assembled onto the substrate but may instead be made directly on the ceramic surface by known technologies. See, for instance, the procedure for creating thermistors on a ceramic substrate shown in U.S. Patent No. 4,129,848 to Franc et al. The leads (422) from the temperature measuring device would allow the variable electrical property of the device to be measured. Additionally, the temperature measuring device (418) may be a RTD device which is commercially and widely available and ideal in this service.

Finally, the catalyst layer (420) may be fairly thin to promote conduction of the heat of reaction produced at the surface to the temperature measuring device (418).

The catalyst (420) used in the catalytic sensor element (410) should promote the reaction of NO_x with the NO_x reductant. Although a variety of metals and oxides can catalyze this reaction, many of these catalyze unwanted reactions making the sensor nonspecific for the measurement of NO_x . The preferred catalysts are those that catalyze only the reaction of NO_x and the co-reactant such as those described in our co-pending application (Attorney Docket No. PA-0009). Example catalysts are V, Fe, Mo, W, Mn, Cu, Ni, Co, Cr, Rh, Ru as the metal or oxide in pure form or mixed with or supported on

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other inert oxides such as SiO_2 , Al_2O_3 , TiO_2 , or mixed oxides such as SiO_2 - TiO_2 , Cr_2O_3 - Al_2O_3 , zeolites, etc. Preferred catalysts comprised at least one of V, Mo, W oxides and Rh and Ru.

5 The catalyst layer (420) may be formed by first applying a high temperature oxide layer, such as TiO_2 , to the temperature measuring device (418). This can be done by known techniques using solutions or colloidal dispersions of the desired oxide followed by heat treating in air or other appropriate gas. Subsequently, the catalyst is applied using a solution of the dried catalytic element in a suitable solvent. Once dipped, sprayed as a wash
10 coat, or otherwise impregnated, the element may be calcined in oxygen or air to produce an active catalyst. Other procedures include vapor disposition, evaporation, and sputtering in an electric discharge or plasma. Reduced platinum group metals such as platinum or palladium, although suitable, may be less desirable at certain higher operating temperature ranges because of
15 their proclivity both for oxidizing residual combustion products such as CO , H_2 , or hydrocarbons and oxidizing the NO_x reductant with O_2 .

A particularly suitable procedure for applying the catalyst to the catalytic sensor element is via application of metal salts of the appropriate catalytic metal to the element support. The salt, preferably a sulfate or chloride, is
20 applied as a saturated aqueous solution to maximize the concentration of catalytic metal applied to the element.

Second, the reference element (412) may be similar in design to the catalytic element (410) except that the catalyst layer is excluded and an optional protective layer (424) for the temperature measuring device may be
25 added.

The reference element (412) is intended to provide a comparative temperature measurement which temperature is that of the non-reacted gas flowing past the reference element or catalyst sensor element. The reference element may, in fact, be an arbitrarily selected fixed value element if the
30 temperature of the gas and the environment "seen" by the catalytic sensor element can be carefully controlled. For instance, if the catalytic sensor element is placed in an iso-thermal environment such that the surrounding temperature is controlled rather than measured, a precision resistor (if the

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temperature measuring device for the catalytic sensor element is a RTD or a thermistor) or a voltage source (if the temperature measuring device is a thermocouple) may be used instead of a reference element which measures local temperature.

5 Neither element is directly heated using, for instance, resistance heating.

 In Figure 4 the reference element (412) may be made up of a mechanical support, a temperature measuring device, and an optional protective layer. The variation shown in Figure 4 includes a mechanical support (416) similar in function to support (414). The temperature measuring
10 device (426) is mounted on the support or, as with the catalytic element, may be produced integrally with the ceramic surface of the support if, of course, the support is ceramic. The protective coating (428) is optional depending upon the corrosivity of the gas stream measured and the reactivity of the temperature measuring device employed.

15 The optional protective coating (428) on the reference element may be of alumina, silica, epoxy polymer, carbon, or other heat conducting material. The coating is to protect the temperature measuring device (426) from corrosive elements, e.g., SO_2 , H_2O , NO_x , etc., in the gas stream but not to interfere in the reference element's task of measuring local temperature.

20 Additionally, the protective coating (428) improves the match of the thermal mass of the reference element (418) and the catalytic sensor element (410). If the catalytic sensor element (410) were to be coated and the reference element were not, the thermal mass of the surface element would be much less and would respond to changes in ambient temperature much more quickly
25 than the catalytic sensor element. Such a response difference clearly could cause errors in the NO_x measurements. Further, the protective coating (428) provides cross-sectional and surface areas of the reference element (410) relatively similar to those of the catalytic sensor element (412). Similarity in those areas also results in similar convective heat transfer loads.

30 The reference element (410) desirably is designed so that the configuration of the gas as it flows past is similar to the flow past the catalytic sensor element (412). Said another way, the aerodynamic shapes of the two elements should be similar. The two elements ideally should be placed in

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similar and representative flow regions in the measured gas, i.e., both should be placed in a turbulent flow region of the gas so that the gas measured is representative. Placement of one element in a boundary layer and another in a turbulent flow region should be avoided.

5 The two elements should be optimized in shape and materials of construction to minimize heat loss via conduction or radiation. Support materials should be selected so that the heat of reaction on the catalytic coating (420) of the catalyst sensor element (410) is maintained at the temperature measuring device (418). The elements should be as small as is
10 practically possible to permit quick resolution of temperature and NO_x contact. Use of small elements also results generally in less radiation heat loss to the surroundings. The two elements should have similar thermal mass. The catalytic sensor and reference elements need not be in the configuration shown in Figure 4.

15 The signals emanating from each of the temperature measuring devices in the catalyst sensor element and the reference element are compared using well-known circuitry (wheatstone bridges, differential amplifiers, etc.) and the NO_x content of the gas stream measured via calibration. Because of the linearity of the inventive assembly, the NO_x concentration may be measured
20 directly after such calibration through the tabs (430).

25

30 This invention has been disclosed both by description and by illustration. The illustrations are only examples and should not be used to limit the claimed invention in any way. Additionally, it will be apparent to a reader having ordinary skill in this art that other variations and equivalents will operate in the same way in measuring NO_x and yet be within the spirit of these claims.

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WE CLAIM AS OUR INVENTION:

1. A self-contained device for measuring NO_x concentration in a flowing gas stream comprising:
 - 5 a. a container adapted to receive a flowing gas containing NO_x,
 - b. a NO_x reductant source situated within the container and adapted to introduce a NO_x reductant into the flowing gas containing NO_x, and
 - 10 c. a heat flux sensor assembly within the container comprising a catalytic sensor element adapted to reduce NO_x with the NO_x reductant and to measure the temperature rise from the reduction and a reference element adapted to measure the
 - 15 temperature of the flowing gas containing NO_x.
2. The device of claim 1 where the NO_x reductant source comprises porous cyanuric acid.
- 20 3. The device of claim 1 where the NO_x reductant source additionally comprises a woven material.
4. The device of claim 1 where the NO_x reductant source additionally comprises glass or mineral wool.
- 25 5. The device of claim 1 where the NO_x reductant source additionally comprises a monolith.
6. The device of claim 1 where the NO_x reductant source comprises a labyrinth.
- 30

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7. The device of claim 1, 2, 3, 4, 5, or 6 additionally comprising a filter for removing particulates from gas containing NO_x before the NO_x reductant is introduced into the flowing gas containing NO_x .
- 5 8. The device of claim 7 additionally comprising a flow controller situated within the container and adapted for controlling the flow of flowing gas containing NO_x through the container.
- 10 9. The device of claim 7 additionally comprising a restrictor adapted to mix NO_x reductant into the flowing gas containing NO_x .
10. The device of claim 1 additionally comprising a heater for heating the NO_x reductant source.
- 15 11. The device of claim 1 or 10 additionally comprising a heater for heating the flowing gas containing NO_x prior to its passage over the heat flux sensor assembly.
- 20 12. The device of claim 1 where the catalytic sensor element comprises a temperature sensing device selected from a thermocouple, RTD, and thermistor.
- 25 13. The device of claim 12 where the catalytic sensor element comprises a catalyst containing a metal or metal oxide of V, Fe, Mo, W, Mn, Cu, Ni, Co, Cr, Rh, or Ru or mixtures.
14. The device of claim 13 where the catalytic element comprises a catalyst containing V, Mo, W oxides; or Rh or Ru.

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15. A self-contained device for measuring NO_x concentration in a flowing gas stream comprising:
- a. a container adapted to receive a flowing gas stream containing NO_x ;
 - b. a NO_x reductant source within the container comprising cyanuric acid and adapted to introduce cyanuric acid into the flowing gas stream containing NO_x ;
 - c. a heater adapted to heat the NO_x reductant source to a temperature between 265°C and 280°C ;
 - d. a heat flux sensor assembly within the container adapted to accept the flowing gas containing NO_x and cyanuric acid, catalytically reduce NO_x with the cyanuric acid, and measure the temperature rise from the reduction; and
 - e. an orifice to control the flow rate through the container of the flowing gas stream containing NO_x .

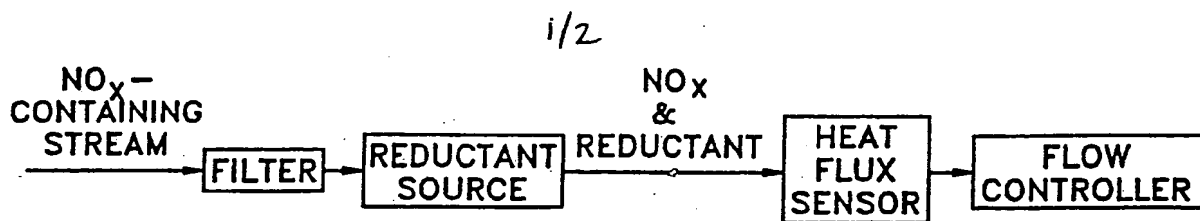


Figure 1

Figure 4

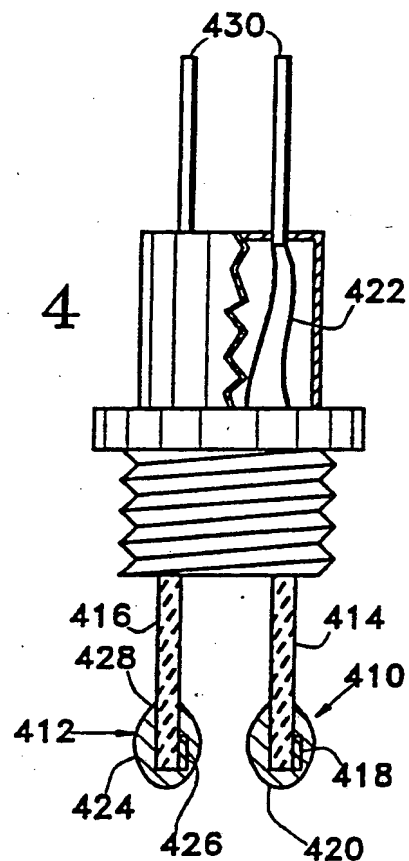
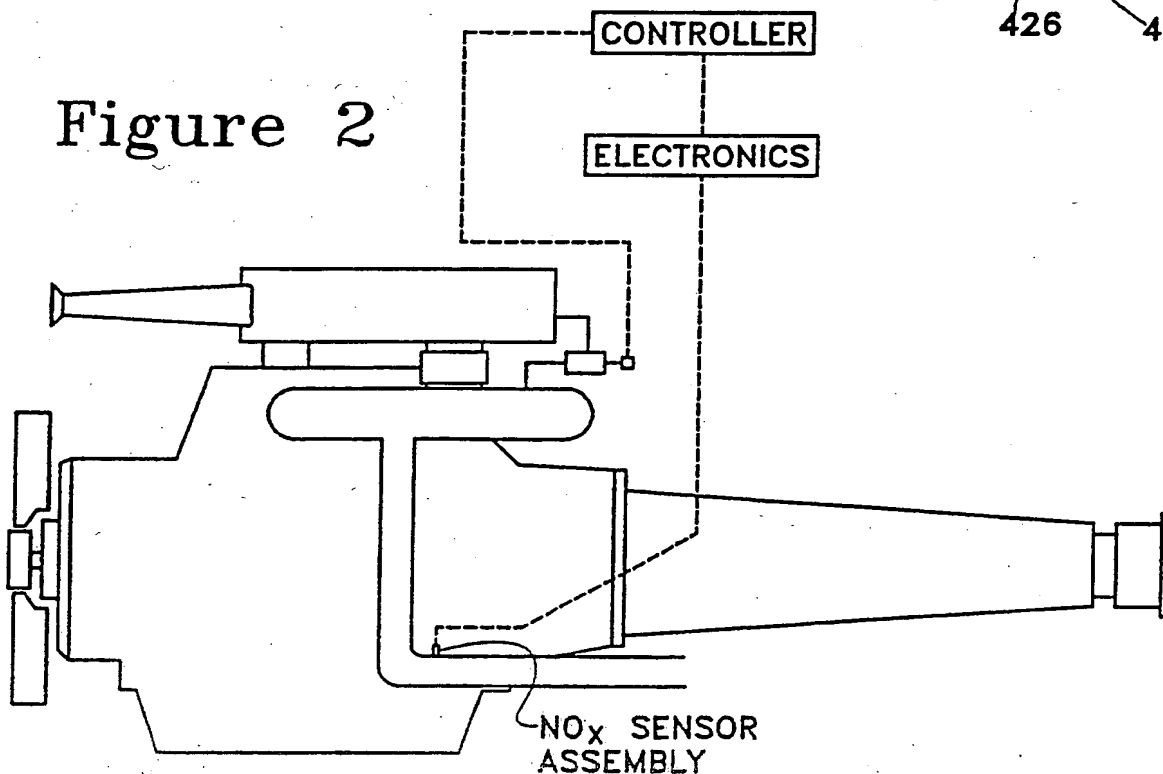


Figure 2



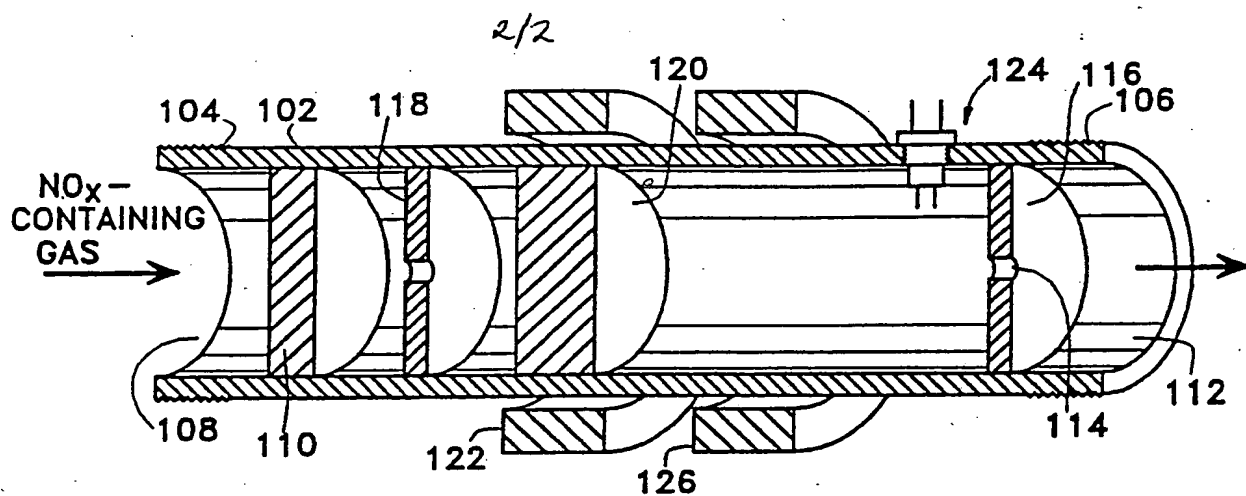


Figure 3-A

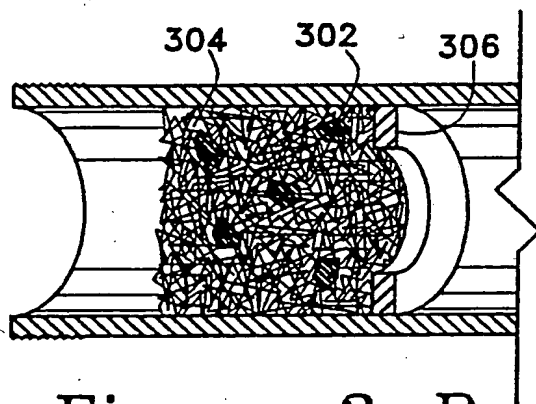


Figure 3-B

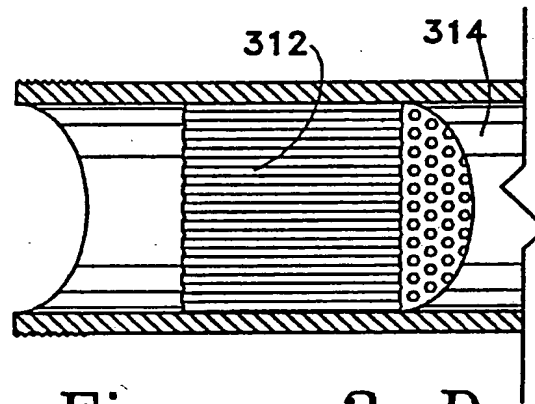


Figure 3-D

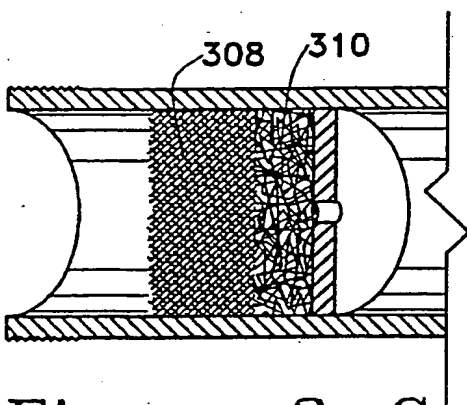


Figure 3-C

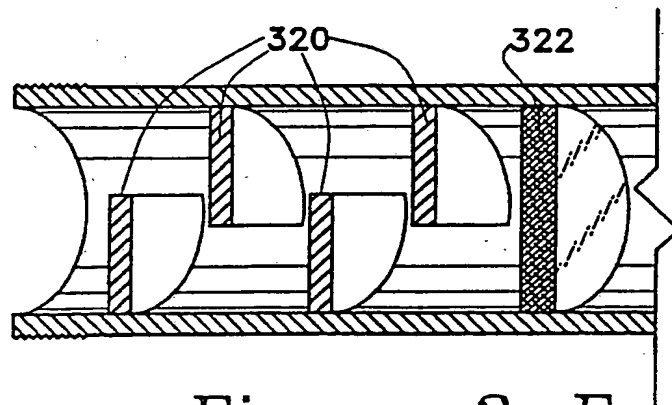



Figure 3-E

INTERNATIONAL SEARCH REPORT

International Application No.

PCT/US91/04177

I. CLASSIFICATION OF SUBJECT MATTER (if several classification symbols apply, indicate all) ⁶ According to International Patent Classification (IPC) or to both National Classification and IPC IPC(5): G01N 33/00, 25/20, 27/00, 21/00; F28D 7/00; B01J 19/00 U.S. Cl.: 436/118; 436/147; 422/235, 239, 82		
II. FIELDS SEARCHED		
Minimum Documentation Searched ⁷		
Classification System	Classification Symbols	
U.S. Cl.:	436/110, 114, 116, 117, 118, 147; 422/98, 82, 235, 239; 73/25.01, 25.03, 23.2	
Documentation Searched other than Minimum Documentation to the Extent that such Documents are Included in the Fields Searched ⁸		
III. DOCUMENTS CONSIDERED TO BE RELEVANT ⁹		
Category ¹⁰	Citation of Document, ¹¹ with indication, where appropriate, of the relevant passages ¹²	Relevant to Claim No. ¹³
Y	US, A, 4,170,455 (Henrie) 09 October 1979. See Fig. 1.	1, 7
Y	US, A, 4,861,567 (Heap et al) 29 August 1989. See entire document.	1
Y	US, A, 3,167,947 (Crawford) 02 February 1965. See Fig. 1.	1, 2, 3
Y	US, A, 4,731,226 (Takahata et al) 15 March 1988, see entire document.	1-5
Y	US, A, 4,532,492 (Esper et al) 30 July 1985. See entire document.	1, 3, 5, 7
<div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p>¹⁰ Special categories of cited documents:</p> <p>"A" document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier document but published on or after the international filing date</p> <p>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p> </div> <div style="width: 45%;"> <p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step</p> <p>"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.</p> <p>"Δ" document member of the same patent family</p> </div> </div>		
IV. CERTIFICATION		
Date of the Actual Completion of the International Search		Date of Mailing of this International Search Report
10 September 1991		24 SEP 1991
International Searching Authority		Signature of Authorized Officer
TSA/IIS		 Newton Edwards